



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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15195

D4038-2

Job Sheet 193124



Part No: D4038-2

Job Qty: 4 pcs

Part Name: Angle, Fwd, RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No: 15195

Due Date: 5/13/19

Created By: Dara Macdonald

Type: ~~SOLD~~ *SLH*

Description:

Note: DWG D4038 REV.F SHEET 4 Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC IPP REV:B 18.02.08 DWG
REV.F DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	4 pcs		5/13/19	0.00	0.42	Bandsaw - 1		<i>DJP 19-05-19</i>
110	HAAS 4 Axis - B4B	4 pcs		5/13/19	0.00	2.40	HAAS - 1 - B4B		<i>DJP 19-05-19</i>
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	4 pcs		5/13/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		<i>DJP 19-05-19</i>
							QC 2 - 57		



Container No: S182370



Part: D4038-2

Job No: 193124

Serial No/Batch: S182370

Revision: F

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.ca

Date: 05/19/19

Plex 4/9/19 9:21 AM Dart.Macdonald.Dara

				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
130 QC 8	4 pcs	5/13/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	mm L (9/05/21)
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
140 Handfinish - 1-1 Chemical-B4B	4 pcs	5/13/19	0.00 0.55	Handfinish - 1 - 1 - B4B	BEB 19-05-21
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	

150 QC 7	4 pcs	5/13/19	0.00 0.00	Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
160 Packaging 3-1 - Stock - B4B	4 pcs	5/13/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	

DAS
MAY 21 2019 40
6-89

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				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	4 pcs	5/13/19	0.00 0.00	QC 21 - SA - 21	DAC 21
				QC 21 - SA - 70	9-50
				QC 21 - SA - 53	MAY 22 2019

Part Op 100 - (Bandsaw) Cut Blank 7.125" long
 Descriptions: 110 - (HAAS CNC Vertical Machine) Mill as per Dwg & Folio FA880 Dwg Rev: _____ Folio Rev: _____ Debur
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 160 - (Identify as per dwg & Stock Location: _____)
 170 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6A4.000W.250	6061T6 Angle 4.00 X 4.00 X .250	2.8000 ft (.7 ea)	100-Bandsaw - 1	5068499

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6A4.000W.250	3	14	0

Part Specifications
Specifications could not be found.

MAT
WED
2.391

DART AEROSPACE LTD		Work Order: 193124
Description: Angle, FWD, RH		Part Number: D4038-2
Inspection Dwg:	Rev: F	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	$\pm .030$	3.998	✓		Vern.	REF
1.25	$\pm .030$	1.248	✓		Vern.	REF
1.25	$\pm .030$	1.244	✓		Vern.	REF
0.250	$\pm .010$	0.253	✓		Vern.	REF
R0.250	$\pm .030$	0.250	✓		R.G.	REF
3.45	$\pm .030$	3.455	✓		Vern.	
2.877	$\pm .005$	2.877	✓		H.G.	
0.708	± $\pm .005$	0.708	✓		H.G.	
0.669	$\pm .005$	0.669	✓		H.G.	
0.581	$\pm .005$	0.583	✓		H.G.	
1.563	$\pm .005$	1.563	✓		H.G.	
1.063	$\pm .005$	1.063	✓		H.G.	
1.00	$\pm .030$	1.00	✓		Vern.	
R0.13	$\pm .030$	0.130	✓		R.G.	TYP
Ø 0.189	$+ .005 / - .001$	0.189	✓		G.P.	2 PL
Ø 0.316	$+ .006 / - .001$	0.316	✓		G.P.	2 PL
2.00	$\pm .030$	2.00	✓		Vern.	
0.563	$\pm .005$	0.563	✓		H.G.	
0.500	$\pm .005$	0.500	✓		H.G.	
1.19	$\pm .030$	1.190	✓		Vern.	
1.00	$\pm .030$	1.00	✓		Vern.	
Ø 0.316	$+ .006 / - .001$	0.316	✓		G.P.	4 PL
2.125	$\pm .005$	2.125	✓		Vern.	
0.911	$\pm .010$	0.909	✓		Vern.	
R0.13	$\pm .030$	0.125	✓		R.G.	
0.882	$\pm .010$	0.879	✓		Vern.	
1.750	$\pm .005$	1.750	✓		H.G.	
7.00	$\pm .030$	7.00	✓		Vern.	
0.50	$\pm .030$	0.498	✓		Vern.	REF

Measured by: DJP	Checked by: gmm	QC Inspector:
Date: 19-05-19	Date: 19/05/21	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	